



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2574

Job Sheet 198058



SCRAP

Part No: D2574

Job Qty: 1 pcs

Part Name: Saddle, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/22/19

Job Tracking No:

Due Date: 7/31/19

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG REV F IPP Rev: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
90	Machining - Issue SN	1 pcs	7/31/19		0.00	0.00	HAAS - 1			
							HAAS - 2			
							HAAS - 3			
							HAAS - 4			
100	HAAS 4 Axis - B4B	1 pcs	7/31/19		1.00	1.61	HAAS - 1 - B4B			
							HAAS - 2 - B4B			
							HAAS - 3 - B4B			
							HAAS - 4 - B4B			
110	Conventional Mill - 1 - B4B	1 pcs	7/31/19		0.00	0.13	Conventional Mill - 1 - B4B			
							Conventional Mill - 2 - B4B			
120	QC 2	1 pcs	7/31/19		0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			



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Container No: S199499



Part: D2574

Job No: 198058

Serial No/Batch: S199499

Revision: Rev.F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/22/19

5/3/20

					QC 2 - 50					
					QC 2 - 51					
					QC 2 - 52					
					QC 2 - 57					
					QC 2 - 62					
					QC 2 - 63					
					QC 2 - 8					
					QC 2 - 66					
					QC 2 - 64					
					QC 2 - 65					
					QC 2 - 5					
					QC 2 - 71					
					QC 2 - 73					
					QC 2 - 69					
					QC 8 - 12					
					QC 8 - 14					
					QC 8 - 17					
QC 8 - 20										
QC 8 - 25										
QC 8 - 3										
QC 8 - 32										
QC 8 - 33										
QC 8 - 35										
QC 8 - 39										
QC 8 - 4										
QC 8 - 44										
QC 8 - 45										
QC 8 - 49										
QC 8 - 58										
QC 8 - 8										
QC 8 - 9										
QC 8 - 68										
QC 8 - 67										
QC 8 - 1 (A)										
QC 8 - 47										
QC 8 - 40										
QC 8 - 52										
QC 8 - 23										
QC 8 - 57										
130 QC 8	1 pcs	7/31/19	0.00 0.00	QC 8 - 12						
				QC 8 - 14						
				QC 8 - 17						
				QC 8 - 20						
				QC 8 - 25						
				QC 8 - 3						
				QC 8 - 32						
				QC 8 - 33						
				QC 8 - 35						
				QC 8 - 39						
				QC 8 - 4						
				QC 8 - 44						
				QC 8 - 45						
				QC 8 - 49						
				QC 8 - 58						
				QC 8 - 8						
				QC 8 - 9						
				QC 8 - 68						
				QC 8 - 67						
				QC 8 - 1 (A)						
				QC 8 - 47						
				QC 8 - 40						
QC 8 - 52										
QC 8 - 23										
QC 8 - 57										
140 Handfinish - 1-1 Chemical-B4B	1 pcs	7/31/19	0.00 0.04	Handfinish - 1 - 1 - B4B						
				Handfinish - 1 - 2 - B4B						
				Handfinish - 1 - 3 - B4B						
				Handfinish - 1 - 4 - B4B						
				Handfinish - 1 - 5 - B4B						
				Handfinish - 1 - 6 - B4B						
				Handfinish - 1 - 7 - B4B						
				Handfinish - 1 - 8 - B4B						
				Handfinish - 1 - 9 - B4B						
				Handfinish - 1 - 10 - B4B						
				Handfinish - 1 - 11 - B4B						
				Handfinish - 1 - 12 - B4B						
				Handfinish - 1 - 13 - B4B						
				Handfinish - 1 - 14 - B4B						
				Handfinish - 1 - 15 - B4B						
				Handfinish - 1 - 16 - B4B						
				Handfinish - 1 - 17 - B4B						
				Handfinish - 1 - 18 - B4B						
				Handfinish - 1 - 19 - B4B						
				Handfinish - 1 - 20 - B4B						
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150 Powdercoat - 1 White Gl(A)- B4B	1 pcs	7/31/19	0.00 0.03	Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
160 QC 3	1 pcs	7/31/19	0.00 0.00	Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	1 pcs	7/31/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	

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				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	7/31/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (HAAS CNC vertical machine #1) Program Batch No. _____ 1-Machine Step No 1 per Folio FA051 and inspect
 Descriptions: per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 110 - (Manufacture as per dwg) Machine keyway as per dwg D2573 & D2574
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	1 pcs (1 ea)	90-Machining - Issue SN	5196167

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-005	1	27	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Aft Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Aft Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Aft Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Aft Inboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Aft Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
7	Saddle, Aft Inboard	0.257Inches + 0.005 - 0.000	0.262 0.257		
8	Saddle, Aft Inboard	0.375Inches + 0.005 - 0.000	0.380 0.375		
9	Saddle, Aft Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
10	Saddle, Aft Inboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
11	Saddle, Aft Inboard	0.558Inches + 0.020 - 0.000	0.578 0.558		
12	Saddle, Aft Inboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
13	Saddle, Aft Inboard	1.365Inches + 0.010 - 0.000	1.375 1.365		
14	Saddle, Aft Inboard	2.495Inches + 0.010 - 0.000	2.505 2.495		
15	Saddle, Aft Inboard	4.119Inches + 0.010 - 0.000	4.129 4.119		
16	Saddle, Aft Inboard	0.115Inches + 0.020 - 0.000	0.135 0.115		

SCRAP

17	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Inboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Aft Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Inboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

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DQA:

Date: 19/07/20

QA Closed:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>1971102 198058</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																																																																																																															
Part No. <u>02574</u>		Rework ☒ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		Skid-tube ☐ Cross tube ☐ Water Jet ☐ Machining ☒ Small Fab ☐ Prod. Eng. Coord. ☐ Thermoforming ☐ Large Fab ☐ Rec/Store/Packaging ☐ Composite ☐ Supplier ☐																																																																																																																																															
NCR No.		Step #: <u>100</u>		QTY Effective : <u>1</u>																																																																																																																																															
Date: <u>19/07/20</u>		Description Work Order Deviation		Disposition																																																																																																																																															
Power outage, tool plunge into the part.		Scrap and replace. Qty 1 Batch # S19C 167		Completed By DAS 57 19/07/20 9-89 Lead hand / Supervisor Approval Verification <i>ant</i> 19/07/22																																																																																																																																															
QC / QA Coordinator DAS 68 40 9-89 9-89 JUL 22 2019		MRB (QS1042) Approval																																																																																																																																																	
<table border="1"> <tr> <th colspan="10">FAULT CATEGORY</th> </tr> <tr> <td colspan="2">Root Cause</td> <td colspan="4">Pressure/Forced</td> <td colspan="2">Temperature/Cure</td> <td colspan="2">Power Loss/Surge</td> </tr> <tr> <td>Environment</td> <td>No Re-verification</td> <td>Bending</td> <td>Set-up</td> <td>Folio/Program</td> <td>Positioned Wrong</td> <td>Design</td> <td>BOM/Route</td> <td>Grain</td> <td>Outside Dimensions</td> </tr> <tr> <td>Operator</td> <td>Offset/Setup</td> <td>Centre Not Concentric</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Over/Under tolerance</td> <td>Doc/Data</td> <td>Inspection Incomplete/Unqualified</td> <td>Wrong Stock Pulled</td> <td>Part Incorrect</td> </tr> <tr> <td>Equip/Tooling</td> <td>Supplier</td> <td>Cracks</td> <td>Contamination</td> <td>Out of Sequence</td> <td>Part Lost/Missing</td> <td>Handling/Pre</td> <td>Countersink</td> <td>Off-set</td> <td>Part Moved</td> </tr> <tr> <td>Material</td> <td>Training</td> <td>Crimp/Kink/Ripple/Wave</td> <td>Cut Too Short</td> <td>Mislabeled</td> <td>Drawing</td> <td>Internal Transport</td> <td>Instructions Incomplete/Unclear</td> <td>Fit/Function</td> <td>Finish</td> </tr> <tr> <td>Internal Knowledge</td> <td>Use for Testing</td> <td>Cuffs</td> <td>Heat Treat</td> <td>Drill Holes</td> <td>Misread</td> <td>Tribal Knowledge</td> <td>Marks/Chatter</td> <td>Turning Sequence</td> <td></td> </tr> <tr> <td>LOA</td> <td>Poor Information</td> <td>Crushing</td> <td>Wave/Twist in Tube</td> <td></td> <td></td> <td>Substation</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Substation</td> <td>Rushing</td> <td>Heat Treat</td> <td></td> <td></td> <td></td> <td>Past Expiry Date</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Past Expiry Date</td> <td>Product Improvement</td> <td>Wave/Twist in Tube</td> <td></td> <td></td> <td></td> <td>Misidentified</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Misidentified</td> <td>Process Improvement</td> <td>Marks/Chatter</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>Manufacturing Process</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>Past Due</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td colspan="2"></td> <td colspan="6">OTHER :</td> <td colspan="2"></td> </tr> </table>								FAULT CATEGORY										Root Cause		Pressure/Forced				Temperature/Cure		Power Loss/Surge		Environment	No Re-verification	Bending	Set-up	Folio/Program	Positioned Wrong	Design	BOM/Route	Grain	Outside Dimensions	Operator	Offset/Setup	Centre Not Concentric	Broken/Damage/Defect	Weld	Over/Under tolerance	Doc/Data	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Incorrect	Equip/Tooling	Supplier	Cracks	Contamination	Out of Sequence	Part Lost/Missing	Handling/Pre	Countersink	Off-set	Part Moved	Material	Training	Crimp/Kink/Ripple/Wave	Cut Too Short	Mislabeled	Drawing	Internal Transport	Instructions Incomplete/Unclear	Fit/Function	Finish	Internal Knowledge	Use for Testing	Cuffs	Heat Treat	Drill Holes	Misread	Tribal Knowledge	Marks/Chatter	Turning Sequence		LOA	Poor Information	Crushing	Wave/Twist in Tube			Substation				Substation	Rushing	Heat Treat				Past Expiry Date				Past Expiry Date	Product Improvement	Wave/Twist in Tube				Misidentified				Misidentified	Process Improvement	Marks/Chatter									Manufacturing Process										Past Due											OTHER :							
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